

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024479**Date Inspected:** 06-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Changxing Island **Location:** Shanghai, China**CWI Name:** Lv Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Vikram Singh was present during the times noted above for observations relative to the work being performed at ZPMC.

NDT

OBG Bay 14

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08070.

Magnetic Particle Testing (MT)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG 13CW & OBG 13BW. The weld designations reviewed is as follows:

DP3146-001-257, 254, 251, 248, 245, 241

DP3133-001-030, 027, 024, 021, 018

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No

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08071.

Magnetic Particle Testing (MT)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG 13CW & OBG 13BW. The weld designations reviewed is as follows:

DP3079-001-021, 033, 039, 042, 069, 077, 085, 090, 098, 101, 106, 125, 138

DP3079-001-147, 159, 170, 178, 189, 188, 194, 197, 210, 291, 303, 313, 321, 342, 352

DP3079-001-355, 372, 404, 414, 424, 434

DP3079-001-019, 028, 035, 075, 100, 109

DP3079-001-148, 156, 173, 187, 196, 201, 221, 224, 227, 230, 292

DP3079-001-356, 376, 396, 408, 419, 428

DP3079-001-311, 322, 323, 344, 345, 364, 363, 383, 384, 415, 416, 436, 435

DP3079-001-150, 157, 190, 206, 207, 282, 283, 304, 305, 324, 325, 346

DP3079-001-012, 031, 047, 046, 063, 062, 071, 070, 086, 087, 092, 093, 102, 103, 117, 118, 126, 127, 132, 133

WELDING

OBG Bay 14

This QA Inspector randomly observed the following work in progress:

Shielded Metal Arc Welding (SMAW)

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3019Q-056 located on Floor Beam stiffener to longitudinal diaphragm of the OBG Segment 14E. The welder is identified as 067764. ZPMC Quality Control (QC) is identified as Mr. Wang Xu. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3019BB-189 located on Floor Beam at PP125 of the OBG Segment 14E. The welder is identified as 201087. ZPMC Quality Control (QC) is identified as Mr. Wang Xu. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3019BB-167 located on Floor Beam at PP125 of the OBG Segment 14E. The welder is identified as 048047. ZPMC Quality Control (QC) is identified as Mr. Wang Xu. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as

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Seg3013AD-046 located on Side Panel to the Floor Beam of the OBG Segment 13AW. The welder is identified as 066361. ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Singh,Vikram	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
